

Work Order ID 51618

August 27, 2009 8:27:11 AM



Item ID: D3535-23 *6Y* Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 8/27/09 Start Qty: 12.00

Required Date: 9/11/09 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *PS mk* Date: *09-8-7*

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304
.046

1-Cut as per Dwg D3535 11 Dwg Rev: *3* 12-
Deburr if necessary

HB 9-10-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

22 5010107

(413)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51618

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Page 2

Item ID: D3535-23

Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 8/27/09 Start Qty: 12.00

Required Date: 9/11/09 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 12-Form joggle as per Dwg D3535 using Jig DT8158 13-Identify as D3535-23

0.00

0.00

880910/08

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 S or 10/08

(13) /

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME: 11:45 FINISH TIME: 12:15

0.00

0.00

BR 09-10-8

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51618

August 27, 2009 8:27:11 AM

Page 3

Item ID: D3535-23

Accept

Revision ID: B

Item Name: Wearshoe

Setup Start

Stop

Start Date: 8/27/09 Start Qty: 12.00

Required Date: 9/11/09 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ll

09/10/09

*X13**q*

170



Packaging

Packaging

Identify as per dwg & Stock Location: *FP-21*

0.00

Memo

0.00

ll

09/10/09

*X13**q*

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09/10/13**W 9.10.09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:11 AM

Page 1

Work Order ID: 51618

Parent Item: D3535-23RevB

Parent Item Name: Wearshoe


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	63.3940	17.1979	18.6310		
												
304/316 .040 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.39404737

110076

31.73

111571

31.6640474

10367

112567

189-107

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: S1618
Description: WEAR SHOE	Part Number: D3535-23
Inspection Dwg: D3535-23 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
300 X 300	+/- .010	302 X 303	*			
Ø .188	+ .005 - .001	.190	*			
6.00	+/- .030	6.00	+			
8.00	+/- .030	8.00	+			
16.00	+/- .030	16.00	+			
24.00	+/- .030	24.00	+			
32.00	+/- .030	32.00	+			
39.00	+/- .030	39.00	+			
48.00	+/- .030	48.00	+			
2.000	+/- .010	2.000	+			
4.750	+/- .010	4.753	+			
9.500	+/- .010	9.500	+			
14.250	+/- .010	14.250	+			
17.750	+/- .010	17.750	+			
23.140	+/- .010	23.140	+			
28.530	+/- .010	28.530	+			
33.920	+/- .010	33.920	+			
39.310	+/- .010	39.310	+			
44.700	+/- .010	44.700	+			
48.200	+/- .010	48.200	+			
52.850	+/- .010	52.850	+			
.040	+/- .010	.034	+			

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 9-10-7	Date: 09/10/07	Date: N/A

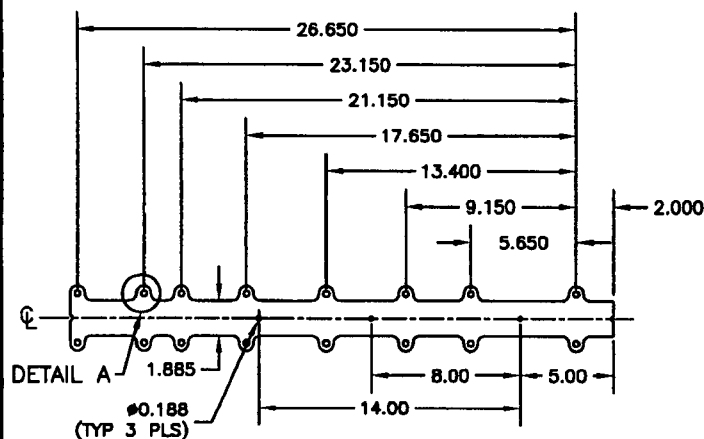
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

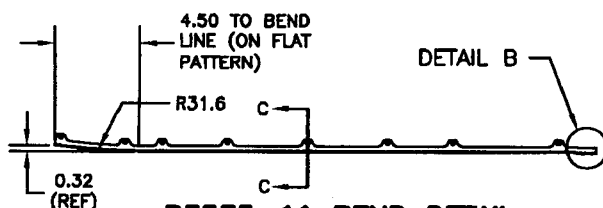
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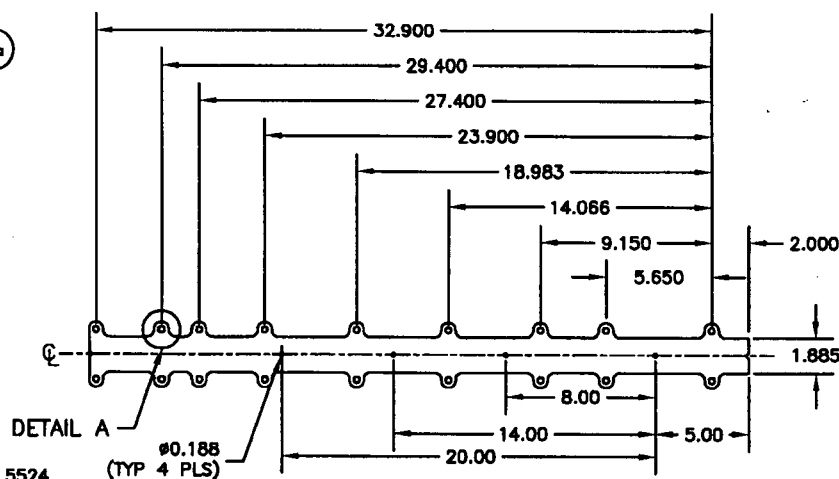
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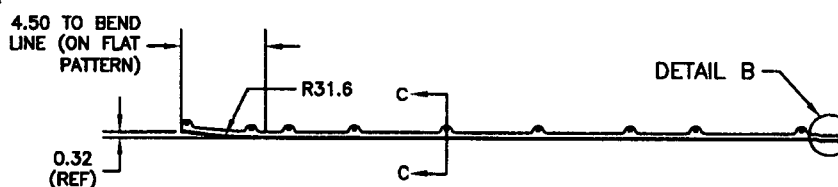
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

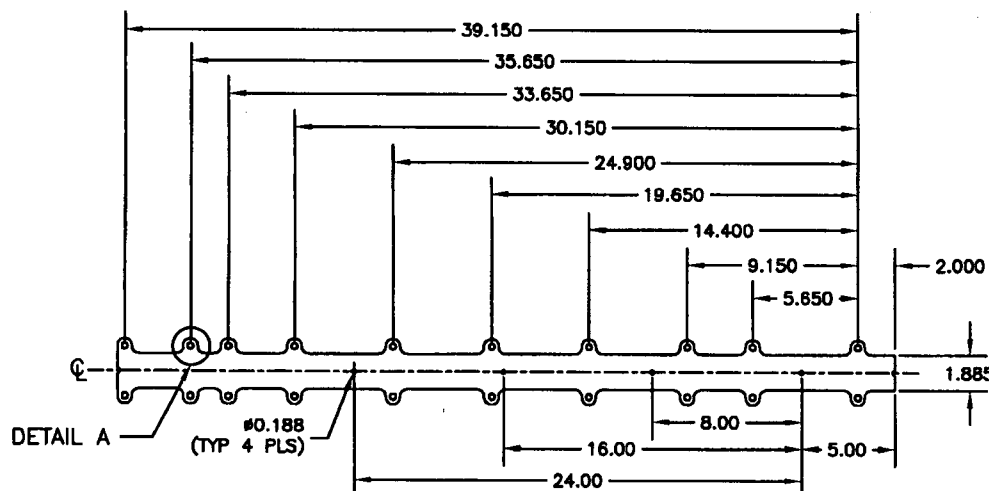
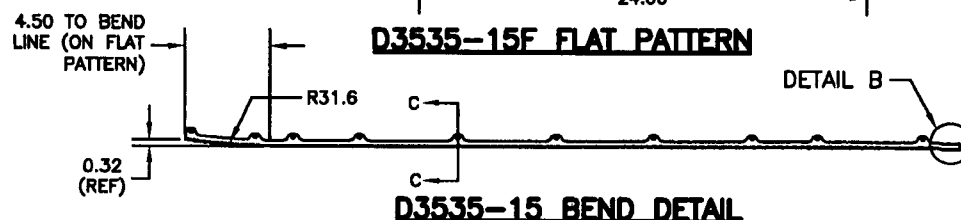
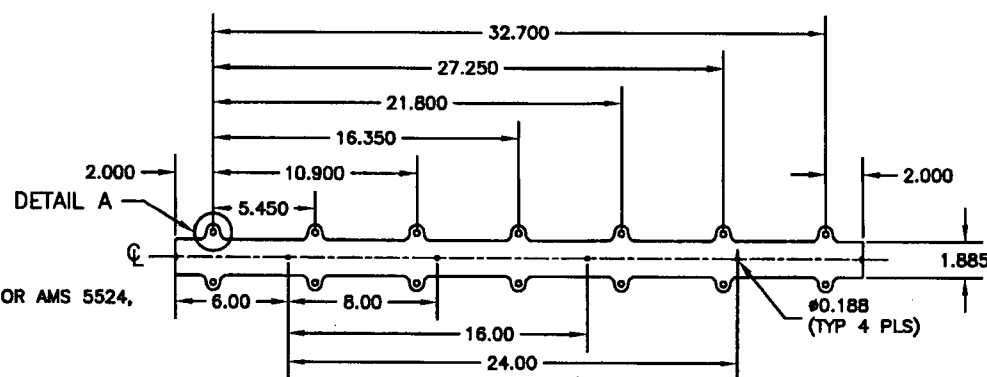
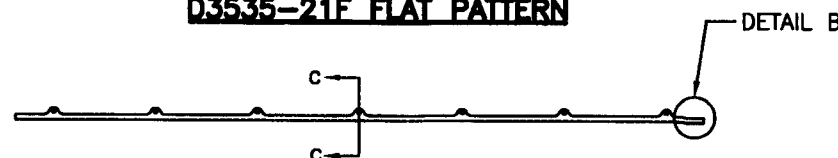
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CB	PH	PORT HADLOCK, WA	
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

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07.04.24

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NO. 31618

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE	TITLE	SCALE	
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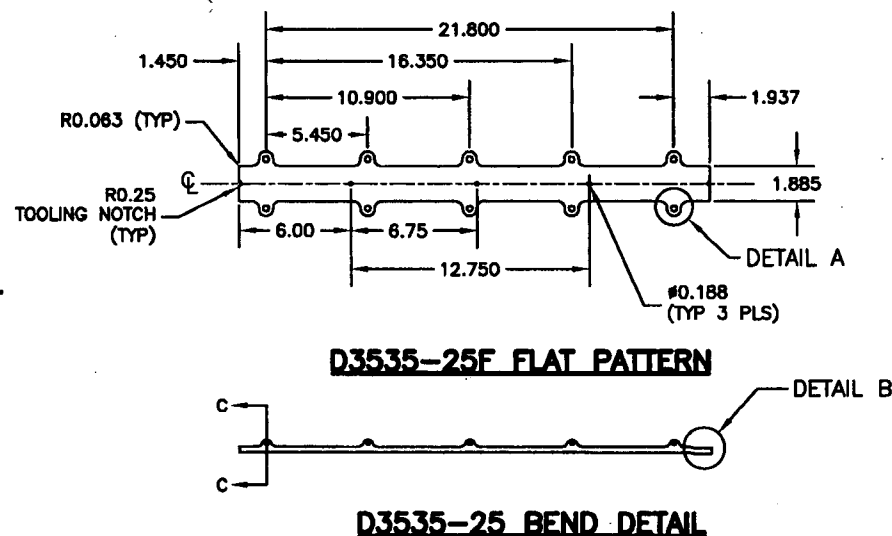
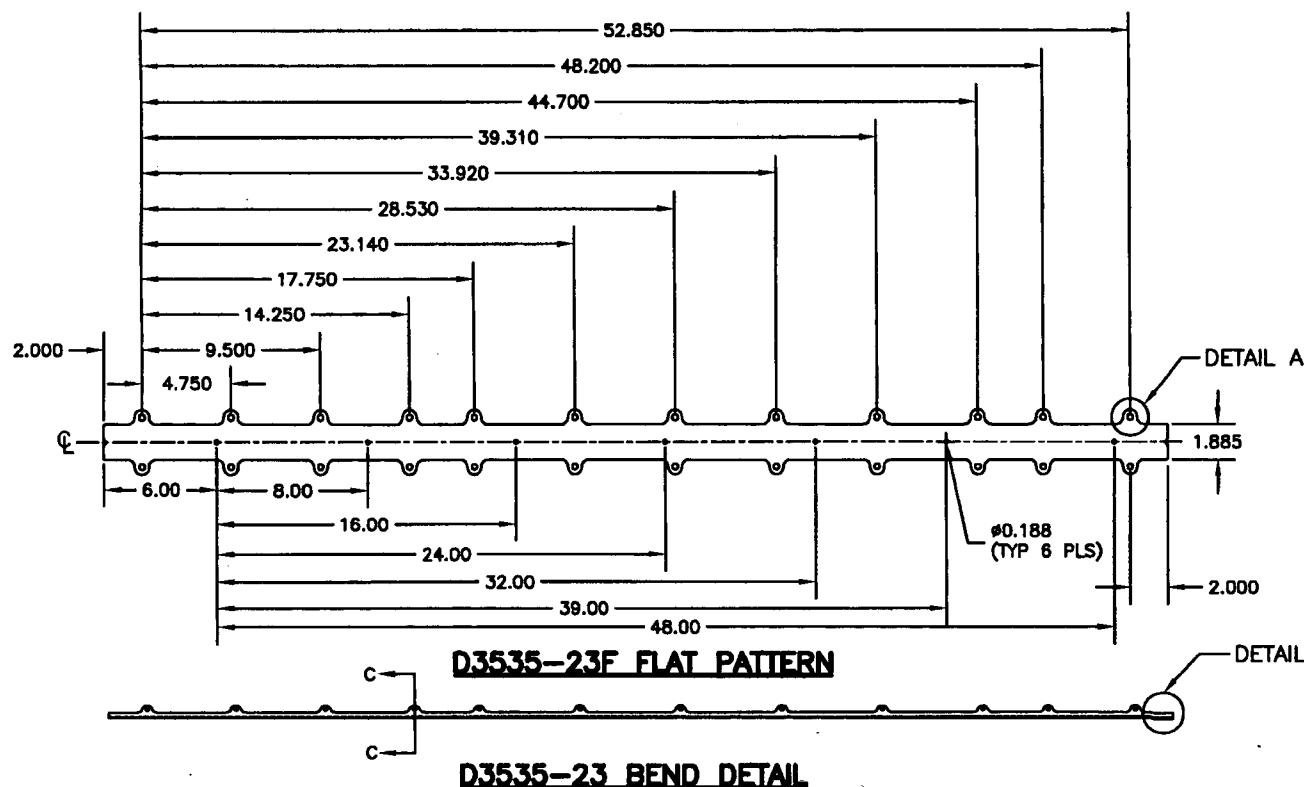
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DATE	TITLE	WEARSHOE	1:10
07.04.17			



NOTES

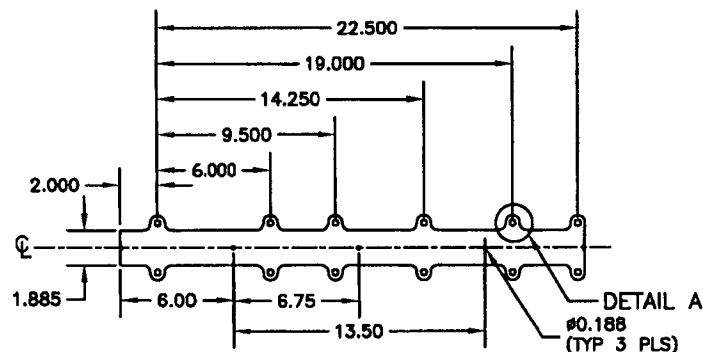
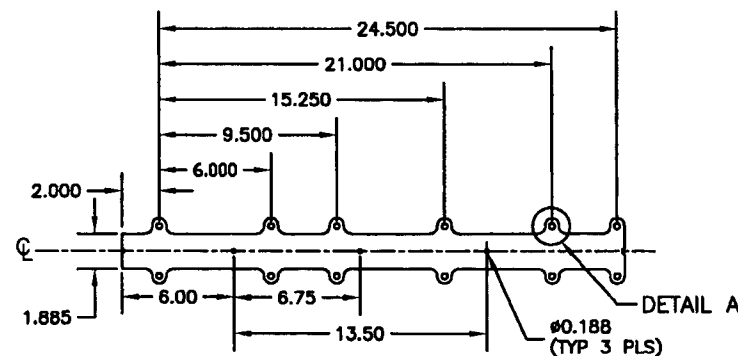
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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NO. 51618

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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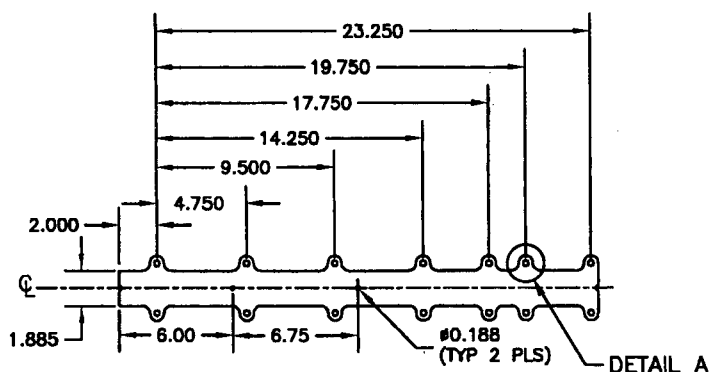
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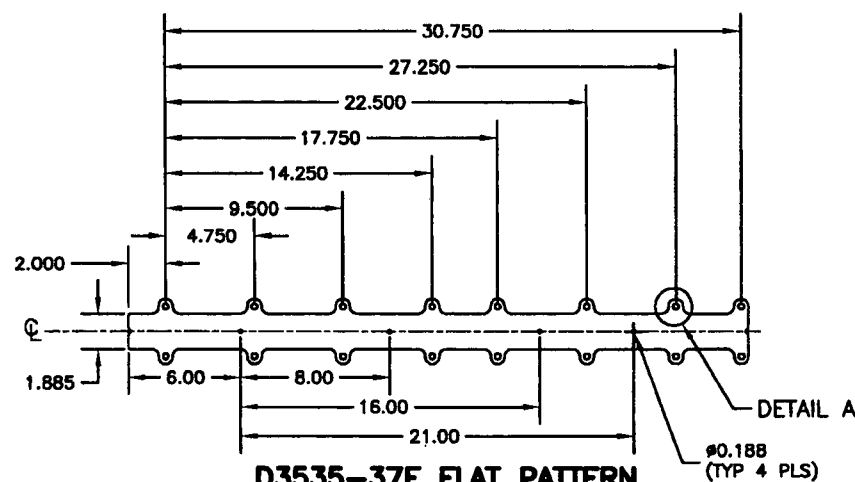
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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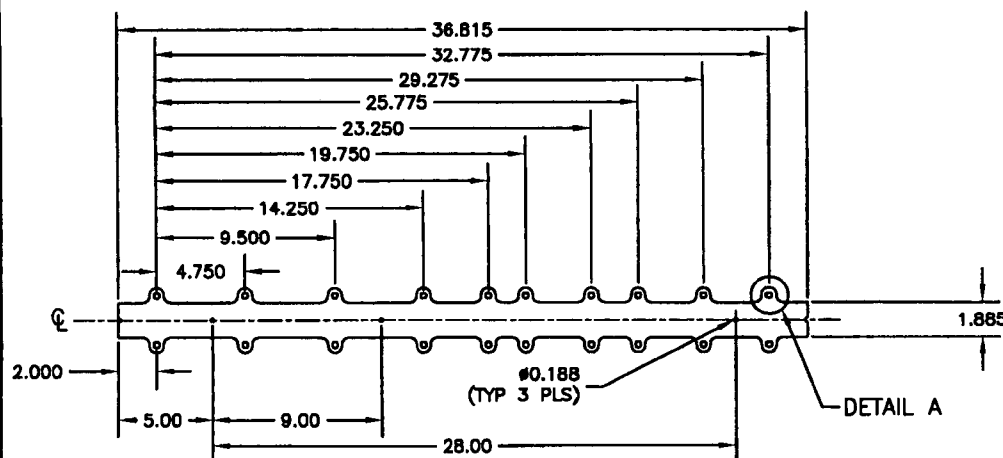
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					1:10

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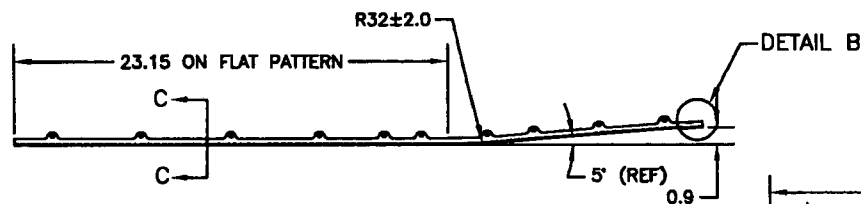
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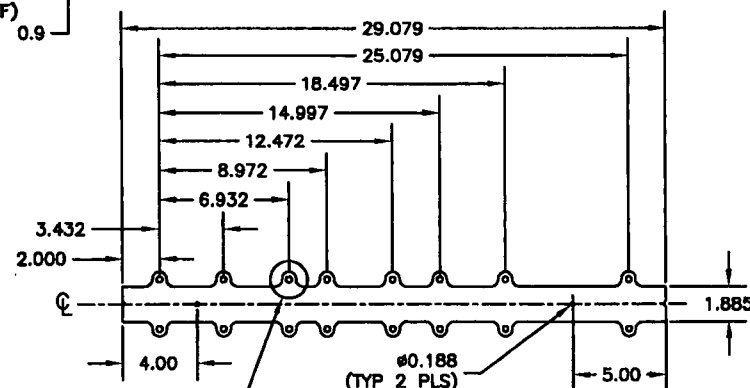
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WORK ORDER
NO. 51618



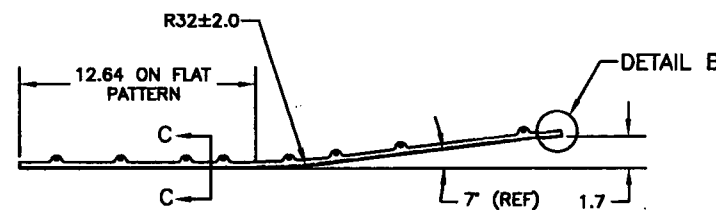
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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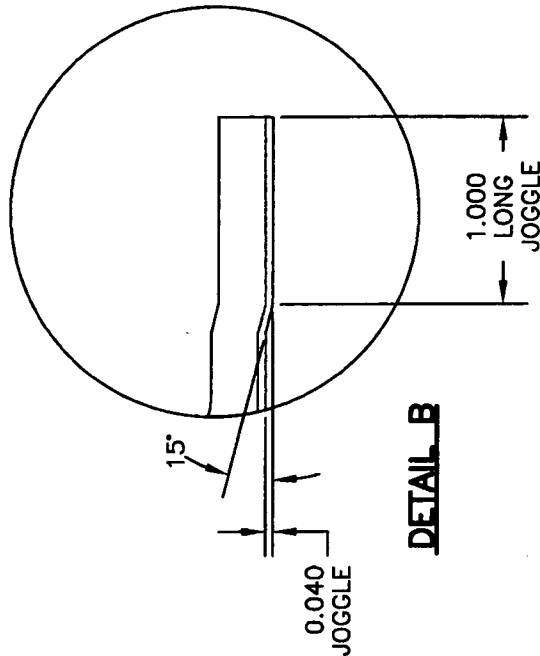
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

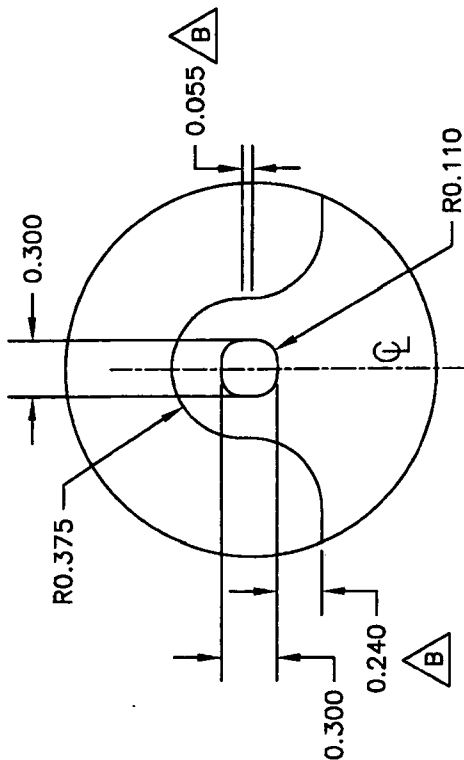
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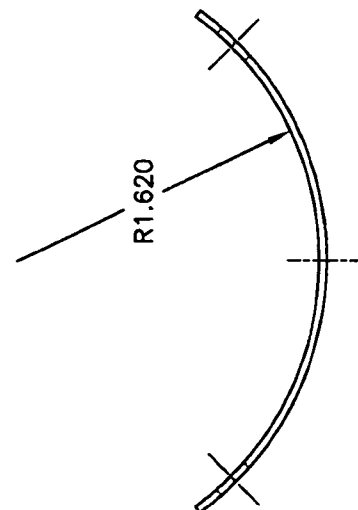


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DETAIL A



SECTION C-C

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